

Date: Monday, 05/03/2007 12:35:29 PM
 User: Linda Lacelle

Process Sheet

split -

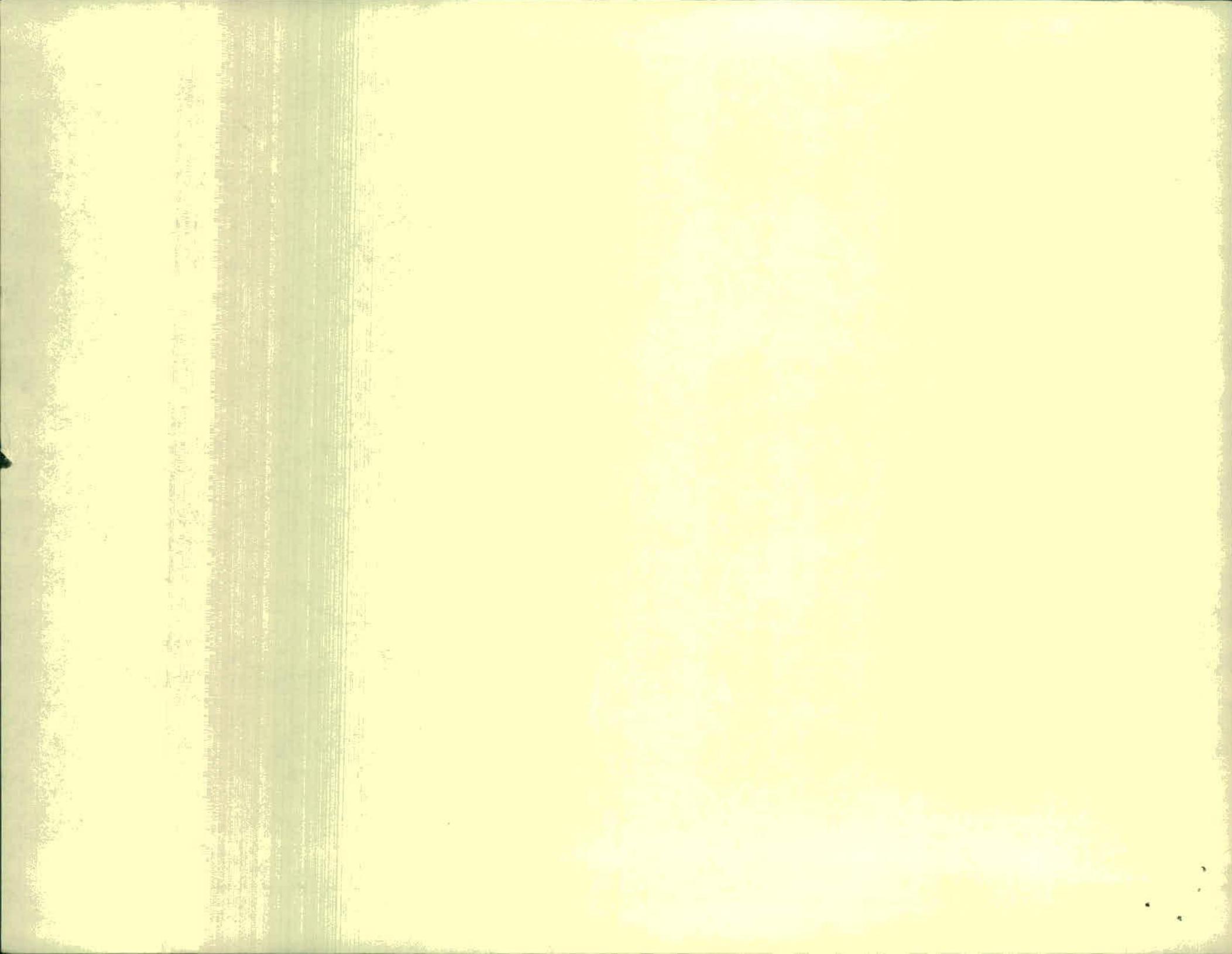
Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 30992-1	Part Number	: D22301
Estimate Number	: 10255	Drawing Number	: D2230 REV F
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 05/03/2007	Drawing Revision	: F
Prsht Rev.	: NC	Material	: N/A
First Issue	: 01/03/2007	Due Date	: 03/12/2007
Previous Run	: 30155	Qty:	400
Written By	:	Um:	Each
Checked & Approved By	:		
Comment	: Est D 05.11.01 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
		Comment: Qty.: 0.0717 f(s)/Unit Total : 28.6860 f(s) Lug Extrusion D2423 Extrusion Batch: 30062	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut D2423 extrusion to 0.82" Batch: _____	
3.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O BLKT 00001 CL 07/03/08 (400) Possible Supplier : Metec Machine per Drwg D2230 Rev. F	
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive & Inspect for transit damage <i>P.C. 1/14 200</i>	
5.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP <i>J0705-07 200 counted</i>	



Date: Thursday, 3/1/2007 11:33:58 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MOUNTING LUG		
Job Number	: 30992						
Estimate Number	: 10255						
P.O. Number	:			Part Number	: D22301		
This Issue	: 3/1/2007	S.O. No.	:	Drawing Number	: D2230 REV F		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type	: MACHINED PARTS	Drawing Revision	: F		
Previous Run	: 30155			Material	:		
Written By	:			Due Date	: 12/3/2007		
Checked & Approved By	: <u>9A07.03.01</u>			Qty:	400	Um:	Each
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC						

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

Comment: Qty: 0.0717 f(s)/Unit Total: 28.6860 f(s)

Lug Extrusion D2423 Extrusion

Batch:

Comment: BAND SAW

Cut D2423 extrusion to 0.82"

Batch:

3.0 HAAS1

HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2230-1

(Check for crack while loading into the machine.)

2-Tumble and deburr rough edges after tumbling

4.G QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8

SECOND CHECK

Comment: SECOND CHECK

100

Date: Monday, 05/03/2007 12:35:29 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30992

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation:

6.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1

Description :

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling



on this
W/O

7.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

(Q06)

M-L

07/05/08

8.0 QC5



INSPECT WORK TO CURRENT STEP



on this w/o

Comment: INSPECT WORK TO CURRENT STEP

9.0 POWDER COATING



POWDER COATING



1103708

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

HS

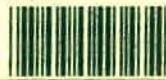
07-05-08

(Q06)

10.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



P-70113

Comment: INSPECT POWDER COAT

11.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

10 7/5/11

SG (206)
Q06

12.0 QC21



FINAL INSPECTION/W/O RELEASE



7/05/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07/05/15

Date: Thursday, 3/1/2007 11:33:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30992

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0 QC21

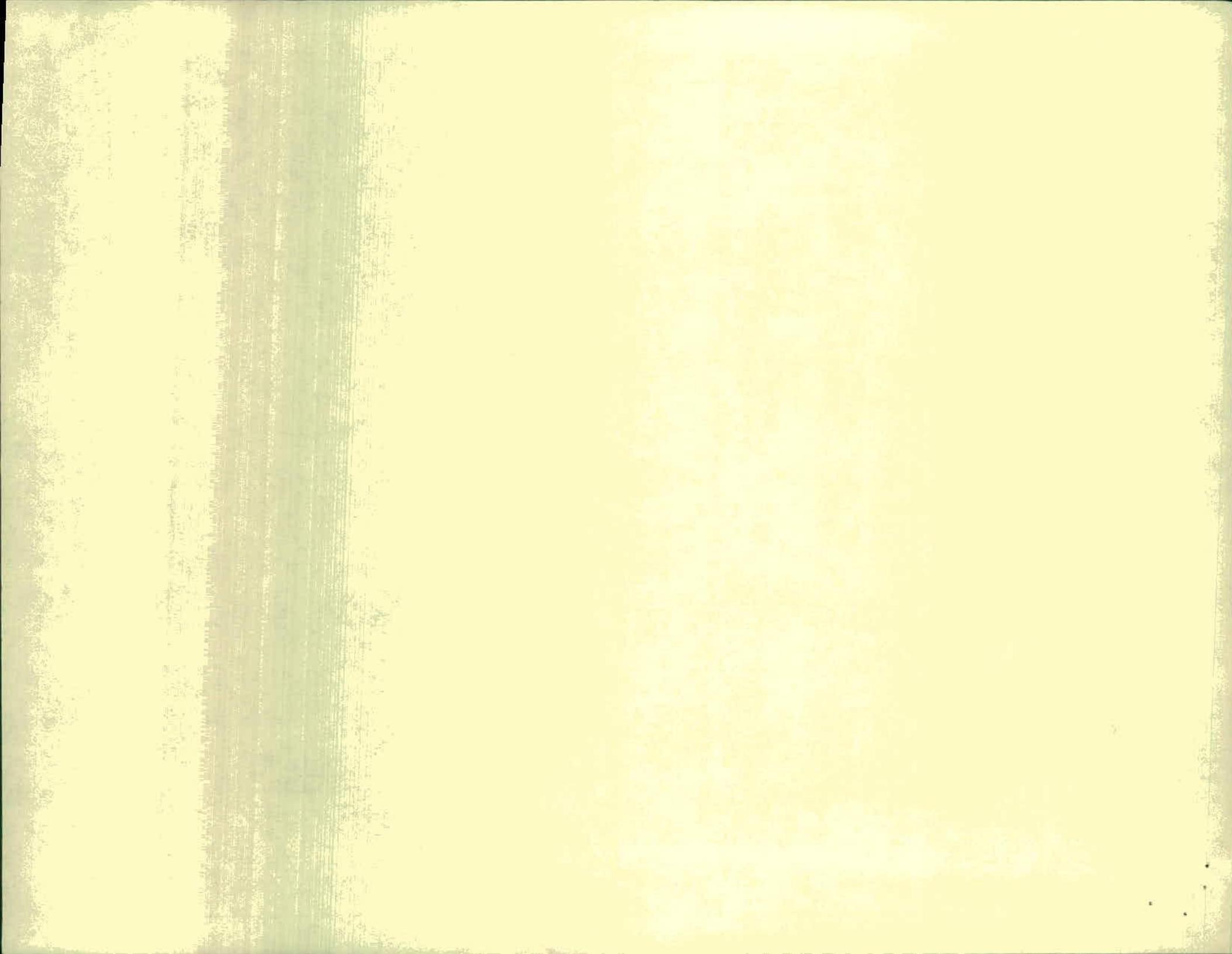
FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

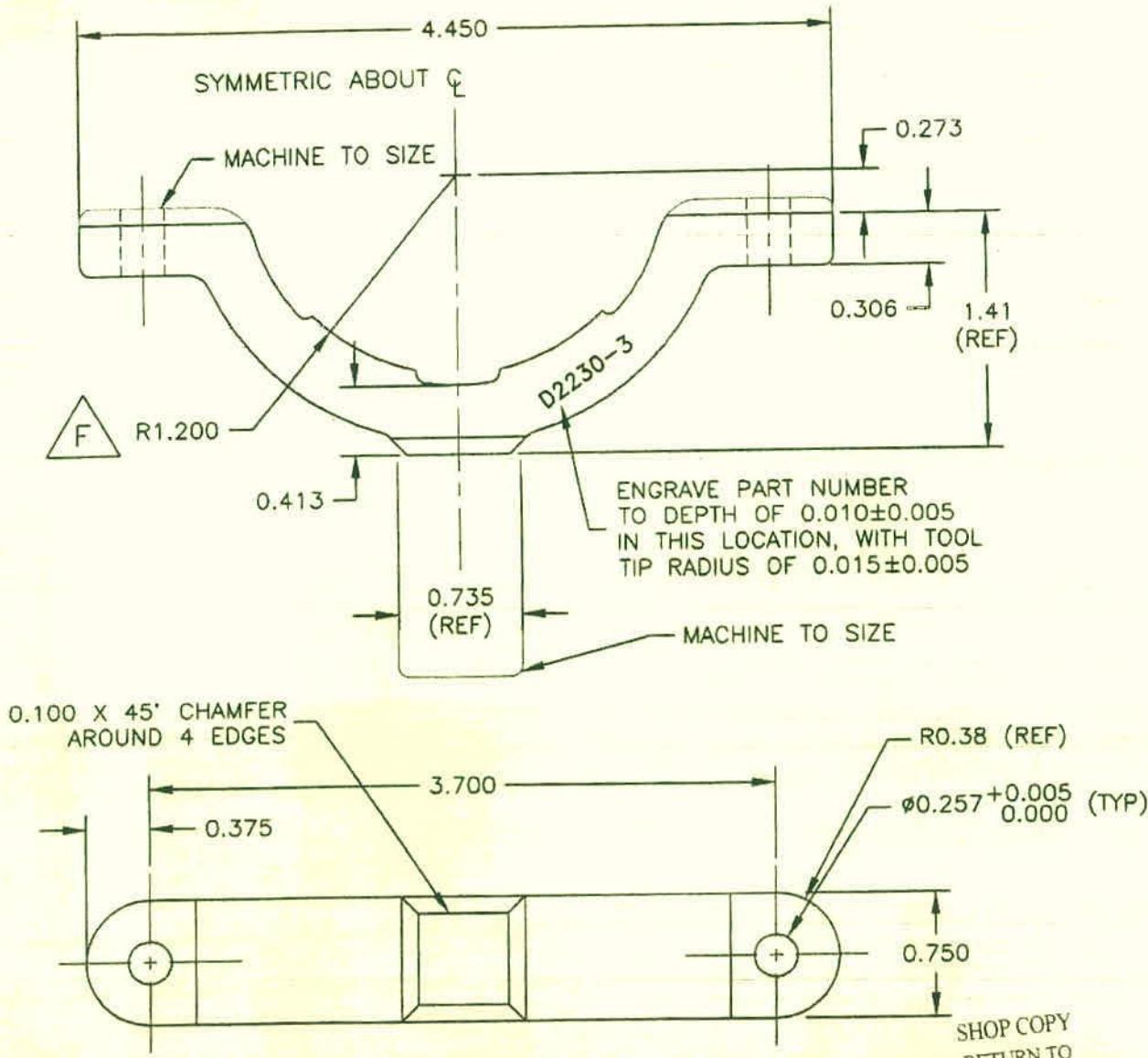




DART

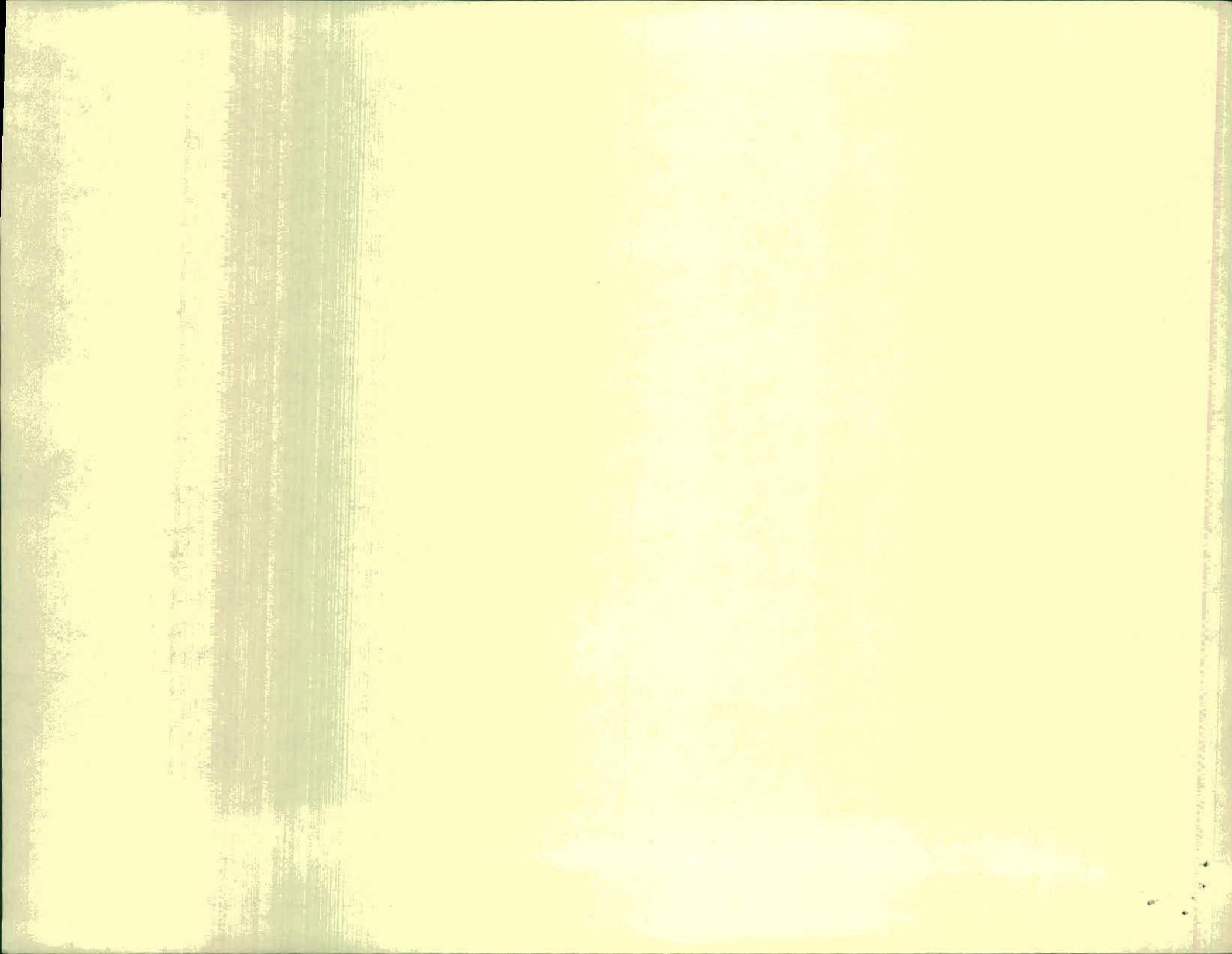
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE		TITLE MOUNTING LUG

REV. F
SHEET 2 OF 2
SCALE
1:1

RELEASED
19.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30992



METEC METAL TECHNOLOGY INC

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

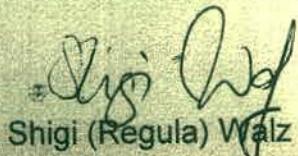
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-1	Lug B30992	BLKT00001

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, May 3, 2007

